

5/43

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	24574
<b>Description: Nut Plate</b>	<b>Part Number:</b>	D3415-041
<b>Dwg: D3415 Rev. B</b>	<b>Qty:</b>	12
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HJ	05.10.17	12
2	PG	Issue P/O: 2008196 Email or Ship DXF file to vendor Laser Cut D3415-1 flat pattern as per Dwg D3415 Possible Supplier: Industrial Laser Material release note is required	U	05.10.17	12
3	RG	Receive and Inspect for transit damage Ensure material release note is attached	CJ	05.10.17	12
4	QC6	Inspect dimensions as per Dwg D3415	2	05.10.17	12
5	GA	Deburr & drill holes as per dwg. D3415	FF	05.10.21	11
6A	GA	C'sink as per Dwg D3415	FF	05.10.24	11
7	FP	Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	MM	05.10.25	11
8	QC3	Inspect Powder Coat	SB	05.10.26	11
9	GA	Install Nut plate as per Dwg D3415 Pick: 20427F3-3 per Chris U Qty Part Number Description Batch 2 MS20613-3C3 Rivet M17654 1 MS21070L4 Nut Plate M18762 Identify as D3415-041	SB	05.10.26	11
10	QC5	Inspect work to Step 9	2	05.10.26	11
11	ST	Identify and Stock	10	05.10.26	11
12	AC	Cost / part: 12.14	54C	05.10.27	11
13	DC	Close W/O 9.96 Inspect Level 21	10	05.10.27	11

Rev	Date	Change	Revised By	Approved
A	05.10.03	New issue	KJ/JLM	

66/QC5 Inspect C'sink

9.96

RELEASED  
05.10.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05-10-17	4	Tool one for show example	<i>[Signature]</i>	05-10-17	1	<i>[Signature]</i> 05-10-17	<i>[Signature]</i> 05-10-17
05-10-25	6	Add QC 5 for c/sink inspection permanent change	<i>[Signature]</i>	05-10-26	1	<i>[Signature]</i> 05-10-26	<i>[Signature]</i> 05-10-25

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

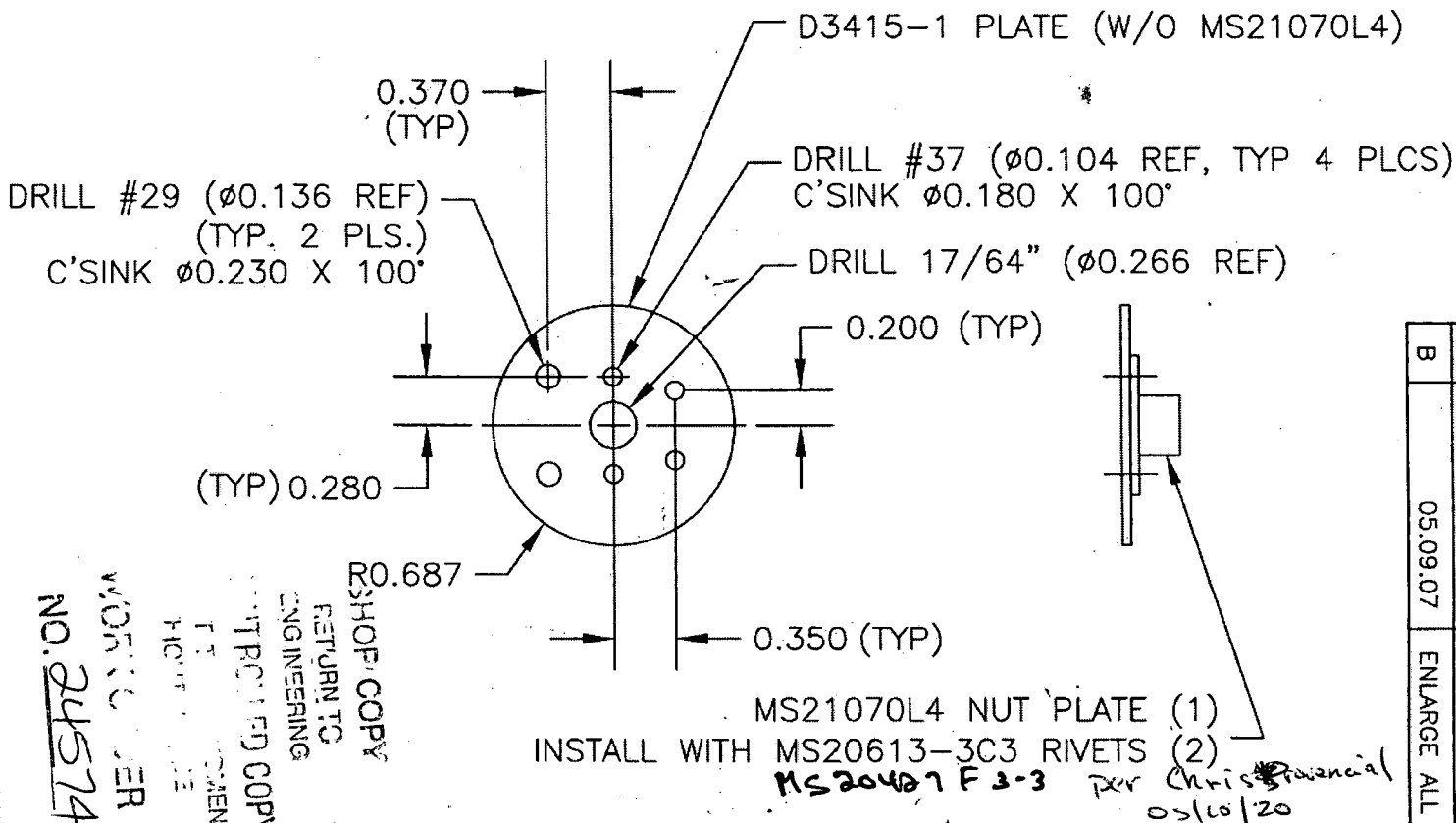
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 05/10/27

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

DESIGN	DRAWN BY	TITLE	REV. B
CP	CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
#	#	D3415	
DATE		SCALE	
05.09.07		1:1	
A	05.03.16	NEW ISSUE	
B	05.09.07	ENLARGE ALL HOLES FOR POWDER COAT	



### D3415-041 NUT PLATE

- 1) MATERIAL: AISI 304 SS SHEET, 0.063 THICK  
(16 GAUGE, REF DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

RELEASED  
05.09.09-11

W/OUT COVER  
NO. 24574  
RESHOPE COPY  
RETURN TO  
ENGINEERING  
FOR PROTECTED COPY  
IT IS NOT TO BE  
REPRODUCED

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Oct 17, 2005  
02:00 pm

Work Order No : 0024574  
Project Name : D3415-~~1~~ 041  
Project For : WK543  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3415-1  
Description :  
Manufactured : No  
Amount Req'd : 0  
Amount Done : 0  
Start Date : 10-17-05  
Est Finish Date :  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
  
Order Entry No :  
OE Value : 0.00  
  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====					
Burden :	0.00	0.00	0.00		
=====					
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

# Purchase Order

PO Number 2008136  
Date 05-30-05  
Account # QSI012-6100

Vendor  
Industrial Laser Cutting  
#7-7504 Vantage Place  
Delta BC  
Canada V4G 1A5

Sold To  
Dart Aerospace Ltd.  
1270 Aberdeen St.  
Hawkesbury ON  
Canada K6A 1K7

Ship To  
S A M E

Attn Jeff/Fenella  
Vendor Tel (604) 946-4152  
Vendor Fax (604) 946-4153

Purchaser  
Telephone (613) 632-3336  
Fax (613) 632-4443

Ship Via PUROLATOR GST # RT101272607 PST # 61225207 OE # 0080304  
FOB Point ORIGIN Comments: MATERIAL CERTIFICATION REQUIRED UPON DELIVERY  
Freight Chgs Collect

Amt	Manuf	Mfg Part No	Our Part Number	Part Description	Delivery	Unit Price	Extended
10.00			.D3413-1	RING	06-10-05	17.7700 /U	177.70
		PER DRWG D3413 REV.A					
20.00			.D3414-1	LUG BRACKET	06-10-05	5.8100 /U	116.20
		PER DRWG D3414 REV.A					
12.00			.D3415-1	NUT PLATE	06-10-05	2.3250 /U	27.90
		PER DRWG D3415 REV.A					
10.00			.D3429-1	WEARPAD	06-10-05	4.1800 /U	41.80
		PER DRWG D3429 REV.A					

P 606-534

Total Value of Purchase Order

\$363.60

9023942

 燦茂實業股份有限公司  
YIEH MAU CORP.

# INSPECTION CERTIFICATE

## MATERIAL TEST/INSPECTION CERTIFICATES

INVOICE NO. : F03MB57  
COMMODITY : PRIME COLD ROLLED STAINLESS STEEL SHEET AISI 304, NO. 4 (SIC)  
FINISH WITH 100 MIC.FILM ON MAIN SIDE, WITH BACK-PASS  
SLITTED EDGE AISI 304, 2B FINISH, WITH PAPER INTERLEAVED,  
SLITTED EDGE  
AISI 304  
SPECIFICATION :  
CUSTOMER : INTEGRIS METALS LTD

工廠:高雄縣路竹鄉順安路345號  
345, SHUN AN RD. LU CHU HSIANG  
KAOHSIUNG TAIWAN R.O.C.  
TEL:(07)6972885 FAX:(07)6973006  
CERTIFICATE NO:9212243  
DATE OF ISSUE:12/31/2003

(ITEM NO) SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties Tensile Test GL=50 m/m					Chemical Composition (%)							
		KGS	LBS			Y.S. (N/mm <sup>2</sup> )	T.S. (N/mm <sup>2</sup> )	EL. (%)	HRB	HV	C x100	Si x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100
AISI 304 2B (7425-4228)																		
24GA/48"X120" (7425-8401)	1	1,442	3,179	YU129992	2AS68986C-1	281	687	56	81	157	4.6	50	110	26	4	804	1819	3.1
20GA/48"X120" (7426-2619)	1	1,446	3,188	YU226021	29S65042BA-21	293	636	58	81	157	4.4	55	115	31	4	808	1808	3.6
18GA/48"X120" (7426-5059)	1	1,428	3,148	YU226201	2AS68982B-21	303	672	56	83	165	4.2	52	115	23	2	814	1824	3.8
16GA/48"X96"	1	1,414	3,117	YU225206	2AS68037-21	301	675	55	81	158	5.5	60	106	26	3	826	1818	2.2
16GA/48"X96"	1	1,412	3,113	YU225206	2AS68037-22	301	675	55	81	158	5.5	60	106	26	3	826	1818	2.2
16GA/48"X96" (7426-5166)	1	1,413	3,115	YU225206	2AS68037-23	301	675	55	81	158	5.5	60	106	26	3	826	1818	2.2
16GA/48"X120"	1	1,385	3,053	YU225390	2AS67026B-1	306	694	50	83	163	5	52	104	23	4	806	1816	2.7
16GA/48"X120"	1	1,385	3,053	YU225390	2AS67026B-2	306	694	50	83	163	5	52	104	23	4	806	1816	2.7
16GA/48"X120" (7426-5455)	1	1,215	2,679	YU225390	2AS67026B-3	306	694	50	83	163	5	52	104	23	4	806	1816	2.7
16GA/60"X96" (7426-5497)	1	1,438	3,170	YU226508	2BS69861A-23	306	687	52	82	160	3.8	50	109	29	6	808	1809	2.6
16GA/60"X120" (7426-5612)	1	1,411	3,111	YU226508	2BS69861A-22	306	687	52	82	160	3.8	50	109	29	6	808	1809	2.6
16GA/60"X144" (7426-7949)	1	1,434	3,161	YU226508	2BS69861A-21	306	687	52	82	160	3.8	50	109	29	6	808	1809	2.6
14GA/48"X96"	1	1,432	3,157	YU130016	2AS68134B-2	304	640	50	83	163	4.8	52	112	26	4	812	1816	2.8
14GA/48"X96" (7426-8053)	1	1,432	3,157	YU130016	2AS68134B-3	304	640	50	83	163	4.8	52	112	26	4	812	1816	2.8
14GA/48"X120"	1	1,435	3,164	YU225138	2AS68038B-1	303	661	50	83	163	4.6	45	104	22	8	812	1805	2.6
14GA/48"X120"	1	1,437	3,168	YU225138	2AS68038B-2	303	661	50	83	163	4.6	45	104	22	8	812	1805	2.6
14GA/48"X120" (7426-8160)	1	1,437	3,168	YU225138	2AS68038B-3	303	661	50	83	163	4.6	45	104	22	8	812	1805	2.6
14GA/48"X144" (7426-8244)	1	1,425	3,142	YU130016	2AS68134B-1	304	640	50	83	163	4.8	52	112	26	4	812	1816	2.8
14GA/60"X96"	1	1,413	3,115	YU130125	2AS69265A-6	299	656	54	83	162	5	47	111	27	2	810	1808	3.6
19		26,834	59,158															

Remarks: NO MERCURY CONTAMINATION  
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS  
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE CONTRACT.

Bend test: good for all Heat NO.

PRODUCT IN ACCORDANCE WITH ASTM A240, A480,  
A262E, ASME SA240, QQS766D.

YIEH MAU CORP.

16ga 304 2B ss

17 15 H.C